

Date: Thursday, 01/05/2008 9:45:51 AM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : MOUNTING LUG
<b>Job Number</b> : 38919	
<b>Estimate Number</b> : 10256	
<b>P.O. Number</b> :	<b>Part Number</b> : D22303
<b>This Issue</b> : 01/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2230, REV F
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : F
<b>Previous Run</b> : 38532	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/05/2008 <b>Qty</b> : 200 <b>Um</b> : Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.5.01</u>	
<b>Comment</b> : Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D2423	Lug Extrusion
-----	-------	---------------



**Comment:** Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)

Lug Extrusion

D2423

Batch: B33310

2.0	BAND SAW	BAND SAW
-----	----------	----------



cut at Meter

**Comment:** Band Saw

Cut D2423 extrusion to 0.82"

Batch: \_\_\_\_\_

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



PG

Issue P/O 6274

**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

Machine per drawing D2230 Rev.F c. 08/05/01

(200)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



PK

Receive + inspect for transit damage  
Ensure C of C attached**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

PC 8/16 P/O

5.0	QC5	SECOND CHECK
-----	-----	--------------



DISPOS

coates

**Comment:** SECOND CHECK inspect level 5

S 08/05/20 (+200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 9:45:51 AM  
User: Julie Lecocq

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 38919

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:15  
320°F  
12:45

M-F

08/05/21

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COATINSPECT POWDER COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1:



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P80/26 200

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-F 08-05-26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

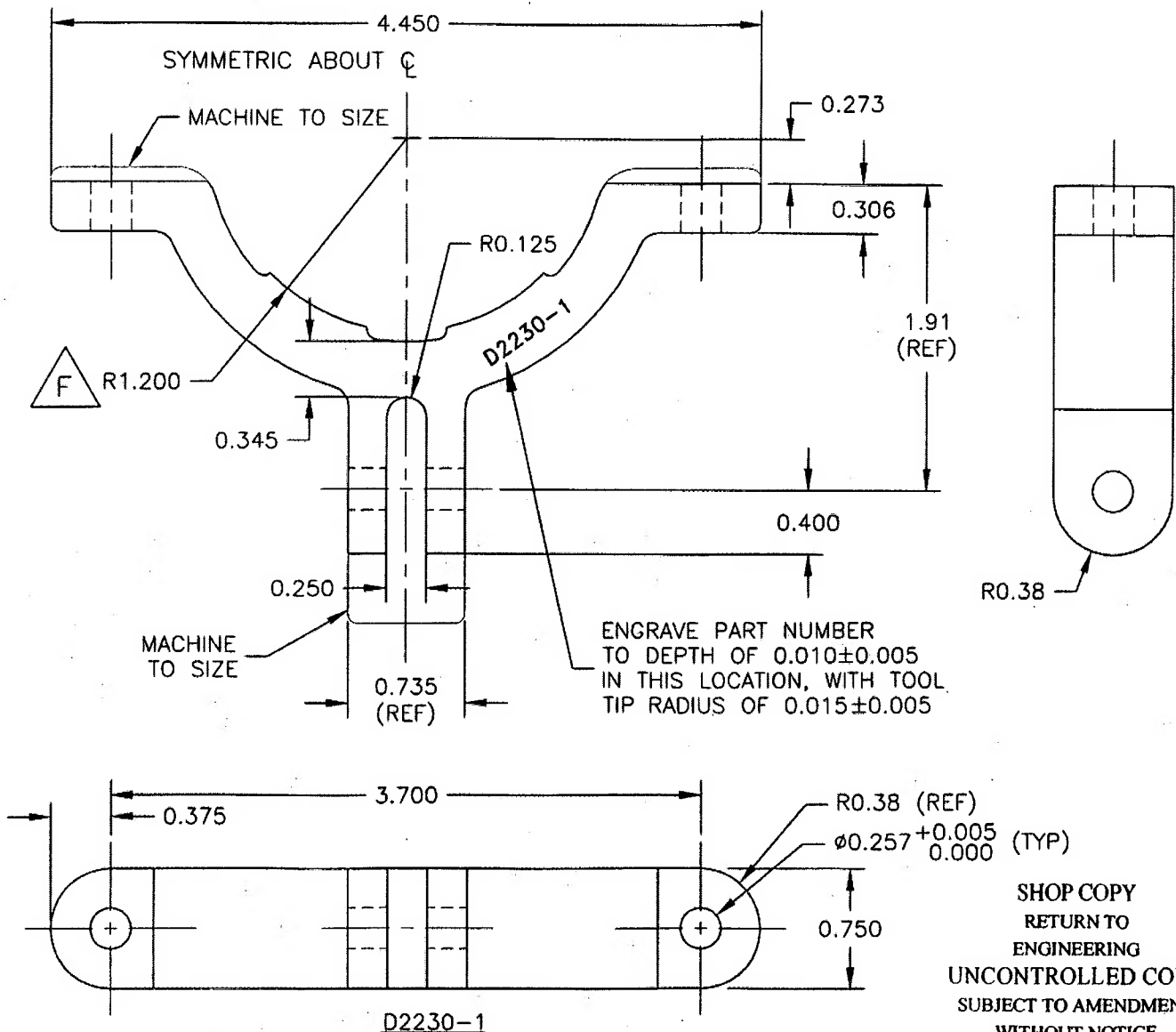
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

**RELEASED**  
99.12.21 DS

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

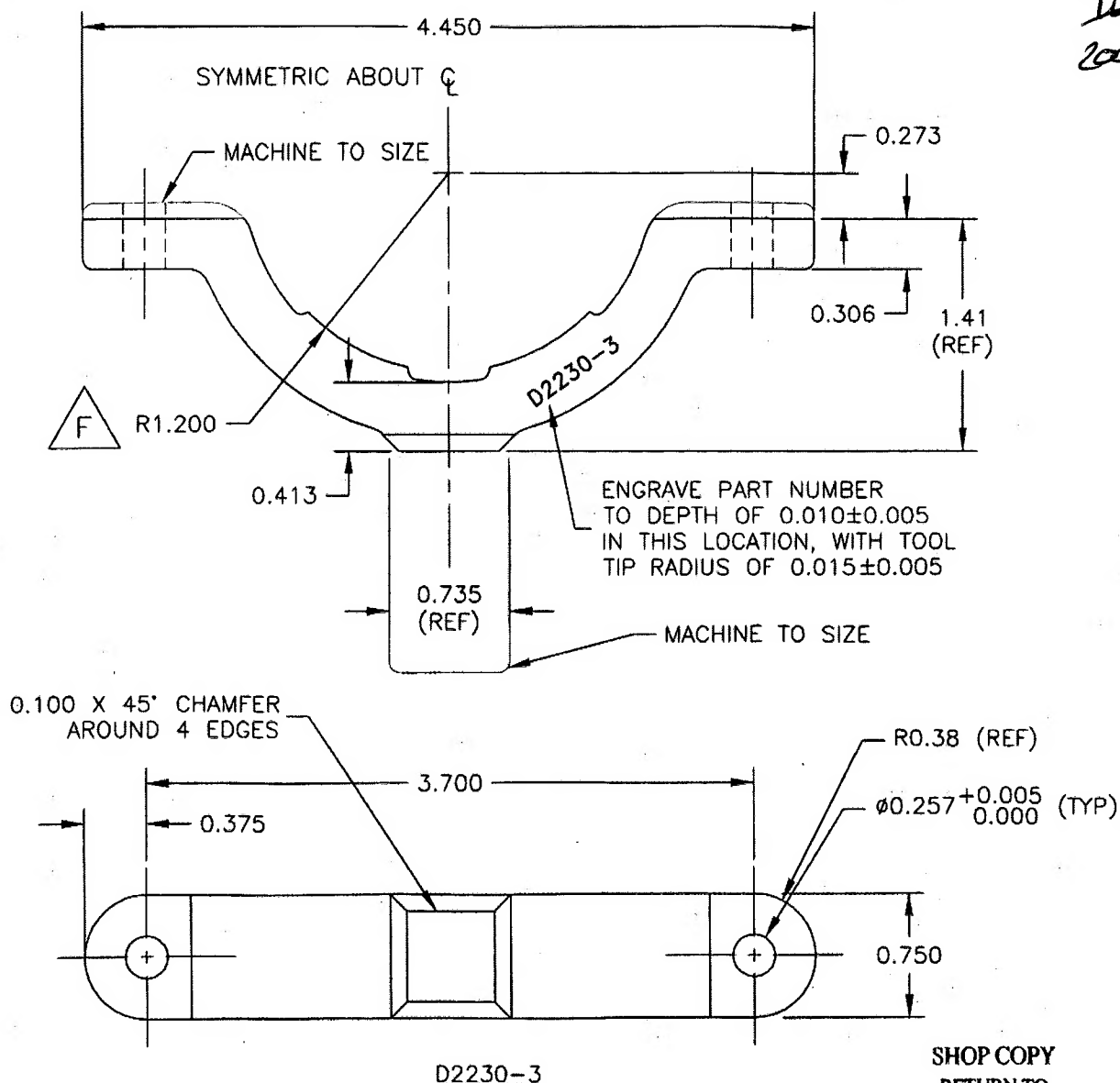
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38919





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
79.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38919







## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPMENT TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

200

D2230-3

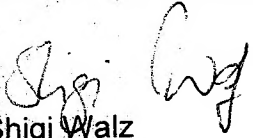
Lug B3319

6276

MATERIAL: supplied by DART D2-23 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

  
Shigi Walz

Vankleek Hill, May 16, 2008

